

BLUE

23

Date: Wednesday, 5/16/2007 8:13:35 AM
User: Kim Johnston

Process Sheet

SPLIT-2

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 32378 -2
Estimate Number : 10832
P.O. Number : N/A
This Issue : 5/16/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : MACHINED PARTS
Previous Run : 31250
Written By :
Checked & Approved By :
Comment : Est: B 00.06.26 New DWG rev (mpp 2069) EC
Est Rev: C As per Rev C 07-03-19 JLM

Drawing Name : 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE
Part Number : D29322UP
Drawing Number : D2932 REV C
Project Number : N/A
Drawing Revision : C
Material : N/A
Due Date : 6/6/2007 Qty: 12 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101003 7075-T7351 2X6.25X7.875



Comment: Qty.: 1.0000 Each(s)/Unit Total: 16.0000 Each(s)
7075-T7351 2X6.25X7.875
Issue material from stock: 7075-T7351 (QQ-A-250/12)
Cut Size 2.0 x 6.25 X 7.88
Grain Along Long 7.88 Length
Batch No: B31387

mk 07/06/29

12

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
Program part number and batch number.
1-Inspect part number and batch number are programmed correctly.
2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet
3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet
4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet
5-Deburr

mk 07/06/29

12

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE
Machine Keyway and inspect per attached dimension sheet

mk 07/06/29

12

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

mk 07/06/29

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: 2 Date: 01/07/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 8:13:35 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE

Job Number: 32378

Part Number: D29322

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JI 04/07/03

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

m-k

(12x)
07/07/04

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

-PRIME

-PAINT DELFLEET BLUE

-CLEAR DELFLEET

VIA

8.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

stock unpacked

5744

PC 7/7/5

(12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(12)
R0707106

Job Completion



h 07-07-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 32378
Description: 206 Saddle, Outboard, Right side	Part Number: D2932-2
Inspection Dwg: D2932 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.127	0.128	0.127	0.126		
B	0.100	0.140		0.126	0.128	0.128	0.127		
C	0.100	0.140		0.119	0.120	0.119	0.120		
D	0.210	0.230		0.223	0.225	0.224	0.225		
E	1.245	1.255		1.250	1.249	1.249	1.250		
F	1.245	1.255		1.250	1.249	1.249	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.510	0.510	0.510	0.516		
I	1.572	1.582		1.577	1.576	1.576	1.576		
J	2.495	2.505		2.499	2.500	2.500	2.499		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.238	0.239	0.239	0.238		
N	0.100	0.140		0.117	0.118	0.118	0.120		
O	0.540	0.560		0.546	0.549	0.548	0.550		
P	0.490	0.510		0.500	0.501	0.503	0.501		
Q	3.715	3.725		3.717	3.717	3.717	3.717		
R	2.470	2.510		2.493	2.492	2.492	2.493		
S	0.240	0.270		0.253	0.254	0.254	0.254		
T	0.100	0.180		0.138	0.140	0.140	0.140		
U	1.625	1.635		1.628	1.628	1.628	1.628		
V	1.362	1.372		1.366	1.367	1.366	1.366		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.125	1.145		1.135	1.136	1.135	1.139		
Y	1.565	1.585		1.574	1.574	1.575	1.576		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: JML
Date: 07/06/29

Audited by: JL
Date: 07/06/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order: 32378
Description: 206 Saddle, Outboard, Right side	Part Number: D2932-2
Inspection Dwg: D2932 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.127	0.129	0.127	0.128		
B	0.100	0.140		0.127	0.128	0.127	0.126		
C	0.100	0.140		0.120	0.120	0.120	0.118		
D	0.210	0.230		0.225	0.224	0.224	0.225		
E	1.245	1.255		1.250	1.250	1.249	1.250		
F	1.245	1.255		1.250	1.250	1.249	1.250		
G	2.495	2.505		2.499	2.499	2.499	2.499		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.239	0.239	0.238	0.239		
N	0.100	0.140		0.120	0.118	0.119	0.118		
O	0.540	0.560		0.548	0.548	0.548	0.550		
P	0.490	0.510		0.501	0.502	0.502	0.502		
Q	3.715	3.725		3.717	3.717	3.717	3.717		
R	2.470	2.510		2.493	2.493	2.493	2.493		
S	0.240	0.270		0.254	0.254	0.254	0.254		
T	0.100	0.180		0.140	0.141	0.138	0.139		
U	1.625	1.635		1.628	1.628	1.628	1.628		
V	1.362	1.372		1.366	1.366	1.366	1.366		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.125	1.145		1.136	1.134	1.134	1.135		
Y	1.565	1.585		1.576	1.573	1.574	1.575		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>JLM</i>
Date: 07/06/30

Audited by: <i>JL</i>
Date: 07/07/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>JLM</i>

DART AEROSPACE LTD	Work Order: 32378
Description: 206 Saddle, Outboard, Right side	Part Number: D2932-2
Inspection Dwg: D2932 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.126	0.127	0.128	0.128		
B	0.100	0.140		0.127	0.127	0.126	0.125		
C	0.100	0.140		0.119	0.118	0.118	0.119		
D	0.210	0.230		0.225	0.225	0.225	0.225		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.499	2.499	2.498	2.500		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.239	0.239	0.239	0.239		
N	0.100	0.140		0.119	0.118	0.119	0.118		
O	0.540	0.560		0.550	0.549	0.550	0.548		
P	0.490	0.510		0.502	0.502	0.501	0.502		
Q	3.715	3.725		3.717	3.717	3.717	3.717		
R	2.470	2.510		2.493	2.493	2.493	2.494		
S	0.240	0.270		0.254	0.254	0.254	0.254		
T	0.100	0.180		0.140	0.141	0.140	0.140		
U	1.625	1.635		1.628	1.628	1.628	1.628		
V	1.362	1.372		1.366	1.366	1.366	1.366		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.125	1.145		1.135	1.135	1.136	1.135		
Y	1.565	1.585		1.575	1.571	1.575	1.575		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	JML
Date:	02/06/20

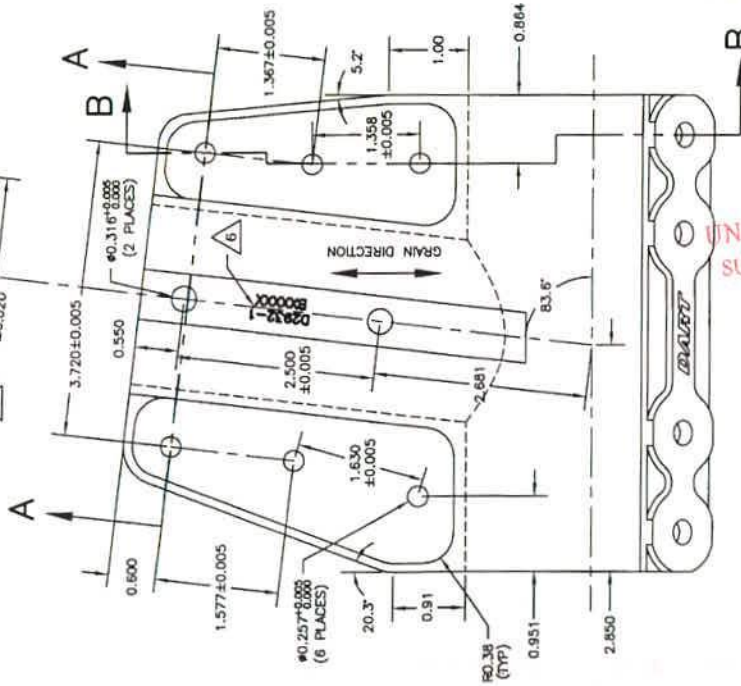
Audited by:	JF
Date:	07/07/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	JML

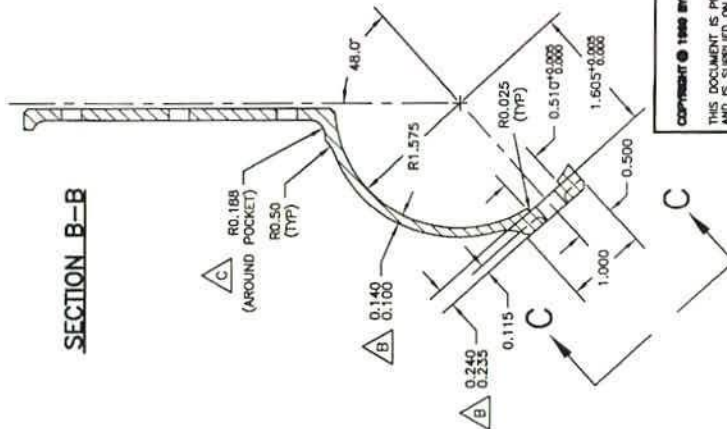
CHAMFER 0.050 X 45°
SURFACE (TYP. 2 PLACES)



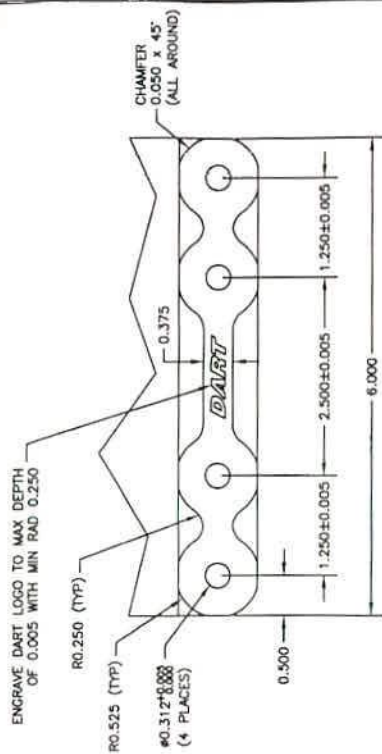
SECTION A-A



SECTION B-B



VIEW C-C



ENGRAVE DART LOGO TO MAX DEPTH
OF 0.005 WITH MIN RAD 0.250

CHAMFER
0.050 X 45°
(ALL AROUND)

D2932-1 LH SADDLE (SHOWN) D2932-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D8101-003 SADDLE BULLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	CB	DART
CHECKED	PH	DRAWING NO. D2932
DATE	06.11.09	TITLE SADDLE OUTSIDE
SCALE		2:3

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NO. 32378

07.02.12